

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-010422**Date Inspected:** 25-Nov-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Li Yang**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Segment**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, M.Manikandan was present during the time noted above for observations relative to the work being performed.

OBG # TRIAL ASSEMBLY YARD (Lift 5 West)

This QA inspector performed dimensional survey on below punch list items after repair. Dimensional data forwarded to team leader for further action

Item number: 1654: 1AW to 1AAW Edge panel transverse splice for skin flatness

OBG # TRIAL ASSEMBLY YARD

This QA inspector performed dimensional survey for offset on T-Rib along with QA inspector (Mr. Manjunath) for below segment. Reports forwarded to team leader for further action.

5AW to 5BW

OBG # TRIAL ASSEMBLY YARD

This QA inspector performed dimensional survey for skin flatness using 630mm straight edge along with QA inspector (Mr. Manjunath) for below segments and readings found to be in general compliance.

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6AE, 6BE and 6CE

This QA Inspector randomly observed the following work in progress:

OBG # TRIAL ASSEMBLY YARD (6AE-6BE)

SMAW Process:

Welding of weld joint –004 located on PCMK OBE6B of 6AE-6BE bottom panel. Welder is identified as 067942. ZPMC CWI is identified as Li Yang. The welding variables recorded by QC appeared to comply with the WPS-B-P-2214-B-U2-FCM-1.

OBG # TRIAL ASSEMBLY YARD (6AE)

SMAW Process:

Welding of weld joint –043 located on PCMK SEG028 of 6AE cross beam side corner assembly weld. Welder is identified as 066236. ZPMC CWI is identified as Li Yang. The welding variables recorded by QC appeared to comply with the WPS-B-P-2212-Tc-U4b-FCM.

SMAW Process:

Welding of weld joint –028 located on PCMK SEG028 of 6AE cross beam side corner assembly weld. Welder is identified as 066236. ZPMC CWI is identified as Li Yang. The welding variables recorded by QC appeared to comply with the WPS-B-P-2214-Tc-U4b-FCM

OBG # TRIAL ASSEMBLY YARD (6BE)

SMAW Process:

Welding of weld joint –001 located on PCMK CA014 of 6BE cross beam side corner assembly weld. Welder is identified as 068764. ZPMC CWI is identified as Li Yang. The welding variables recorded by QC appeared to comply with the WPS-B-P-2212-Tc-U4b-FCM.

SMAW Process:

Welding of weld joint –002 located on PCMK CA014 of 6BE cross beam side corner assembly weld. Welder is identified as 068764. ZPMC CWI is identified as Li Yang. The welding variables recorded by QC appeared to comply with the WPS-B-P-2214-Tc-U4b-FCM

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

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The incident report is issued for the above mentioned dimensional discrepancy observed in 5BE. And prior to issue it was informed to ZPMC QC and ABF QA.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact , who represents the Office of Structural Materials for your project.

Inspected By:	Manikandan,Murugan	Quality Assurance Inspector
Reviewed By:	Miller,Mark	QA Reviewer
